

Work Order ID 52139

Thursday, September 17, 2009 8:08:43 AM

Page 1

Item ID: D209-669-013

Accept

Revision ID: B

Item Name: Skidtube LH

Start Date: 9/18/2009 Start Qty: 1.00

Required Date: 10/9/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D209-669-013	Rev B								
DSI 9450	Rev A								

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP d209-669-013 CHG003

502/10/05

110

0.00



Packaging

Pick Kit

Memo

0.00

Packaging

10/1/09 (1)

52100

Work Order ID 52139

Thursday, September 17, 2009 8:08:43 AM

Page 2

Item ID: D209-669-013

Accept

Setup Start

Revision ID: B

Stop

Item Name: Skidtube LH

Start Date: 9/18/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 1.00

Customer:




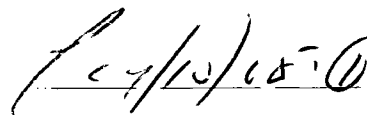

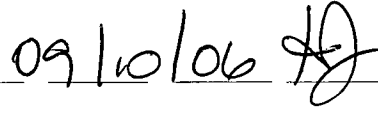
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00	25 09/10/05						
130  Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPPD209-669-013 Location: _____	0.00 0.00							
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							 MF 09-10-06

Picklist Print

Thursday, September 17, 2009 8:08:42 AM

Page 1

10

Work Order ID: 52139

Parent Item: D209-669-013RevB

Parent Item Name: Skidtube LH

Comments:

Start Date: 9/18/2009

Required Date: 10/9/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D209-669-043RevB

Manufactured

No

110

Each

3.0000

1.0000



Replacement Skidtube



52106

9/14/09 (1)

Warehouse

Loc Qty

Loc Code

Location

Premier

Mezz

3

22797

1

39205

1

39206

1

D2917-1RevB

Manufactured

No

110

Each

0.0000

2.0000



Saddle LH



352126 9/14/09 SP

D2918-1RevB

Manufactured

No

110

Each

3.0000

2.0000



Saddle LH



52131 9/14/09 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

43755

1

51329

2

Picklist Print

Page 2

Thursday, September 17, 2009 8:08:42 AM

Work Order ID: 52139



Parent Item: D209-669-013RevB



Parent Item Name: Skidtube LH


Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-51A  Bolt		Purchased	No			110	Each	354.0000	8.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	354	
110328	2	
111635	102	
112314	100	
112489	100	
112641	50	

M112314

D2570RevB

Manufactured No

110

Each

139.0000

24.0000



Bushing



B52214

PC 9/14/2

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	15	
47246	15	
Main Warehouse		
ST36	124	
50356	124	

Thursday, September 17, 2009 8:08:42 AM

Shop Packet Print

Page 2

Picklist Print

Thursday, September 17, 2009 8:08:42 AM

Work Order ID: 52139

Parent Item: D209-669-013RevB

Parent Item Name: Skidtube LH


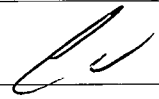
Comments:

Start Date: 9/18/2009

Required Date: 10/9/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S MS21042L4  Nut		Purchased	No			110	Each	8,148.000	24.0000	✓		

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	8148	
107499	5	
108145	4	
110450	1	
110507	184	
111827	5996	
112314	1893	m112314
15924	0	
7690	24	
8182	41	

AN5-36A



Bolt

Purchased

No

110

Each

555.0000

4.0000





<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	555	
109545	11	
110467	7	
110731	4	
112243	20	
112314	463	m112314
112385	50	

Picklist Print

Page 4

Thursday, September 17, 2009 8:08:42 AM

Work Order ID: 52139



Parent Item: D209-669-013RevB



Parent Item Name: Skidtube LH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD516

Purchased

No

110

Each

1,097.000

8.0000



Washer



1112794

CU

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1097

100564

2

106167

6

107534

34

107959

43

108246

46

108672

2

109059

49

109752

22

110363

46

110523

57

111279

43

112082

247

112314

500

MS21042L5

Purchased

No

110

Each

1,279.000

4.0000



Nut



1291061

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1279

110382

10

111636

269

112314

1000

1111636

Thursday, September 17, 2009 8:08:42 AM

Shop Packet Print

Page 4

Picklist Print

Page 5

Thursday, September 17, 2009 8:08:42 AM

Work Order ID: 52139



Parent Item: D209-669-013RevB



Parent Item Name: Skidtube LH



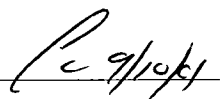
Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-7A  Bolt		Purchased	No			110	Each	201.0000	16.0000 		7/12/2009 	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

201

111668

1

112314

50

112385

50

112641

100

Picklist Print

Page 6

Thursday, September 17, 2009 8:08:42 AM

Work Order ID: 52139

Parent Item: D209-669-013RevB

Parent Item Name: Skidtube LH


Comments:

Start Date: 9/18/2009

Required Date: 10/9/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416 S  Washer		Purchased	No			110	Each	8,313.000	32.0000 ✓			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	8313	
102929	2	
105906	4	
106277	2	
107321	23	
107939	114	
108161	553	
108827	31	
109249	69	
110523	340	
111279	101	
111916	2187	m111916
112314	4887	
16941	0	

D2929RevB

Manufactured No

110

Each

15.0000

2.0000 ✓

Spacer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	15	
43376	15	

Thursday, September 17, 2009 8:08:42 AM

Shop Packet Print

Page 6

Picklist Print

Page 7

Thursday, September 17, 2009 8:08:42 AM

Work Order ID: 52139



Parent Item: D209-669-013RevB



Parent Item Name: Skidtube LH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
5 D2930RevB Spacer		Manufactured	No			110	Each	11.0000	2.0000 ✓ 	52247		

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

11

43378

11

5 D3405-041RevB Lug Assembly		Manufactured	No			110	Each	10.0000	1.0000 	51573		
-------------------------------------	--	--------------	----	--	--	-----	------	---------	------------	-------	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

10

51254

10

5 AN4C47A Bolt		Purchased	No			110	Each	222.0000	4.0000 ✓ 			
-----------------------	--	-----------	----	--	--	-----	------	----------	--------------	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

222

110847

4

112431

18

112489

100

112641

100

1112489

Thursday, September 17, 2009 8:08:42 AM

Shop Packet Print

Page 7

Picklist Print

Thursday, September 17, 2009 8:08:42 AM

Work Order ID: 52139



Parent Item: D209-669-013RevB



Parent Item Name: Skidtube LH


Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-4  Nut		Purchased	No			110	Each	1,397.000	5.0000			

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG 40

104603 40

Main Warehouse

ST 1357

111819 35

112243 22

112314 1000

112492 300

D3405-043RevB

Manufactured

No

110

Each

12.0000

1.0000



Lug Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 12

46589 1

46863 1

51255 10

Picklist Print

Page 9

Thursday, September 17, 2009 8:08:42 AM

Work Order ID: 52139



Parent Item: D209-669-013RevB



Parent Item Name: Skidtube LH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3407-041RevE Manufactured No

110

Each

35.0000

1.0000 ✓



Tow Ring

[Signature]

Warehouse
Location

Loc Qty

Loc Code

OFFSHORE

FG

3

35780

3

Main Warehouse

ST

1

48356

1

Main Warehouse

ST464

31

51659

31

D3456-1RevA Manufactured No

110

Each

232.0000

1.0000 ✓



Washer

51659

[Signature] (1)

Warehouse
Location

Loc Qty

Loc Code

OFFSHORE

FG

7

25701

7

Main Warehouse

ST

225

46752

25

51653

200

46752

Thursday, September 17, 2009 8:08:42 AM

Shop Packet Print

Page 9

Picklist Print

Page 10

Thursday, September 17, 2009 8:08:42 AM

Work Order ID: 52139



Parent Item: D209-669-013RevB



Parent Item Name: Skidtube LH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3417-5RevE		Manufactured	No			110	Each	152.0000	2.0000 ✓			

S



Washer



(C 9/10/09)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

152

51649

152

51649

Thursday, September 17, 2009 8:08:42 AM

Shop Packet Print

Page 10

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52139

INSTRUCTIONS:

1) FOR D209-669-011/-012/-013/-014 SKID TUBES @ CHANGE 003 AND SUBSEQUENT, MODIFY THE FOLLOWING:

- a) REPLACE THE D2968-041 TOW RING WITH THE D3407-041 TOW RING ASSEMBLY.
- b) REPLACE THE D2736-1 AND D2736-3 GHW LUGS WITH THE D3405-041 AND D3405-043 LUG ASSEMBLIES.
- c) AMEND THE PARTS LIST IN SECTION 5.0 OF INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B AS SHOWN ON PAGE 2 OF THIS DSI.

NOTE: ALL INSTALLATION FASTENERS FOR THE ABOVE CHANGES HAVE BEEN UPDATED. SEE THE AMENDED PARTS LIST ON PAGE 2 FOR DETAILS.

A	NEW ISSUE	AJS	09.02.24
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
DATE	09.02.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

5.0 PARTS LIST

52139

ITEM	QTY -011	QTY -012	QTY -013	QTY -014	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X						D209-669-011	SKIDTUBE INSTALLATION, LH (AH-1W/J)
		X					D209-669-012	SKIDTUBE INSTALLATION, RH (AH-1W/J)
			X				D209-669-013	SKIDTUBE INSTALLATION, LH (AH-1P/F/S)
				X			D209-669-014	SKIDTUBE INSTALLATION, RH (AH-1P/F/S)
	1	1			X		D209-669-041	REPLACEMENT SKIDTUBE (AH-1W/J)
			1	1		X	D209-669-043	REPLACEMENT SKIDTUBE (AH-1P/F/S)

IS:

50	4	4	1	1			D3405-041	LUG ASSEMBLY
51	8	8	4	4			AN4C47A	BOLT
52	16	16	8	8			D2570	BUSHING
53	8	8	4	4			MS21043-4	NUT
54			1	1			D3405-043	LUG ASSEMBLY
60	1	1	1	1			D3407-041	TOW RING ASSEMBLY
61	1	1	1	1			D3456-1	WASHER
62	1	1	1	1			MS21043-4	NUT
63	2	2	2	2			D3417-5	WASHER

WAS:

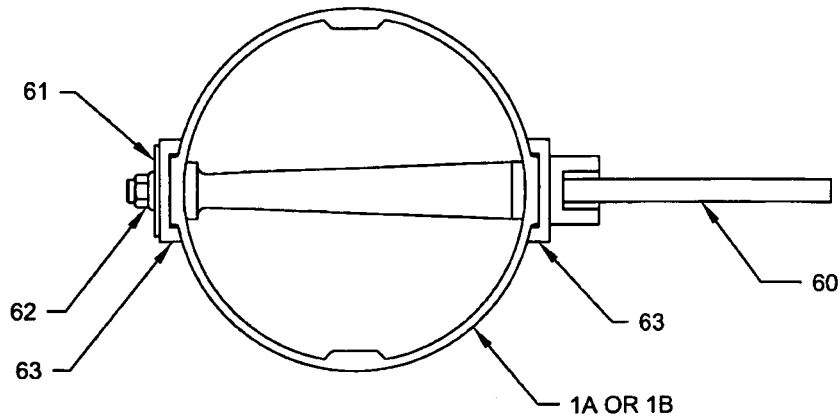
50	4	4	1	1			D2736-1	GHW LUG
51	8	8	4	4			AN4-46A	BOLT
52	16	16	8	8			D2570	BUSHING
53	8	8	4	4			MS21042L4	NUT (OR MS21042-4)
54			1	1			D2736-3	GHW LUG
60	1	1	1	1			D2968-041	TOW RING
61	1	1	1	1			AN970-4	WASHER
62	1	1	1	1			MS21042L4	NUT (OR MS21042-4)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
DATE	09.02.24	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

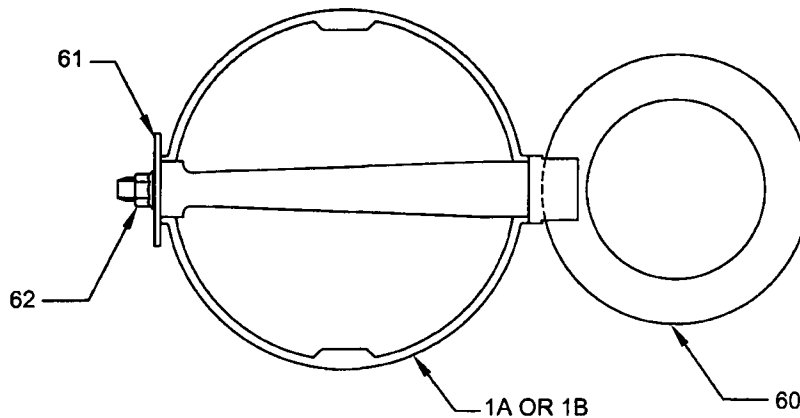
INSTALL TOW RING ASSEMBLY AS SHOWN BELOW (REFER TO SECTION F-F OF IIN-D209-669 REV. B.

52139

IS:



WAS:



NO PICTORIAL CHANGE REQUIRED FOR GROUND HANDLING WHEEL LUG CHANGES.

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE INSTALLATIONS	NTS
DATE	09.02.24	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	